

Date: Tuesday, 4/17/2007 3:57:07 PM  
 User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 31937		
Estimate Number	: 12712		
P.O. Number	: <u>N/A</u>	Part Number	: D35371
This Issue	: 4/17/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3537 UNDER REVIEW <u>PH</u>
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 31725	Drawing Revision	: <u>AB</u>
		Material	: <u>N/A</u>
Written By	:	Due Date	: 5/20/2007
Checked & Approved By	:	Qty:	40 Um: Each
Comment	: Est Rev:A New Issue 07-02-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0788 sf(s)/Unit Total : 3.1500 sf(s)  
 M304S16GA .063" 304 SS SHEET  
 Batch: M103961

SAP 07/05/13

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3537  
 Dwg Rev: B  
 Prog Rev: B

SAP 07/05/13

2-Deburr if necessary

MF 07-05-17

(40)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/05/13

(40)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

RG 07-05-14

40

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.  
 2-Identify as D3537-1

MF 07-05-17 (40)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: Q Date: 07/06/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:57:08 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31937

Part Number: D35371

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M102956

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpad if necessary

FC 07/06/13 (40)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/12 (40)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/06/12 (40)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101001

BR

07-06-13 (40)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L

07/06/13 (40X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FLP 18

M-L

07/06/13 (40X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14 (40)

Job Completion



U 07/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

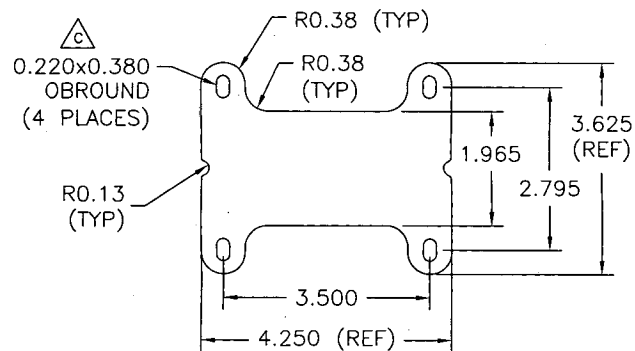
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

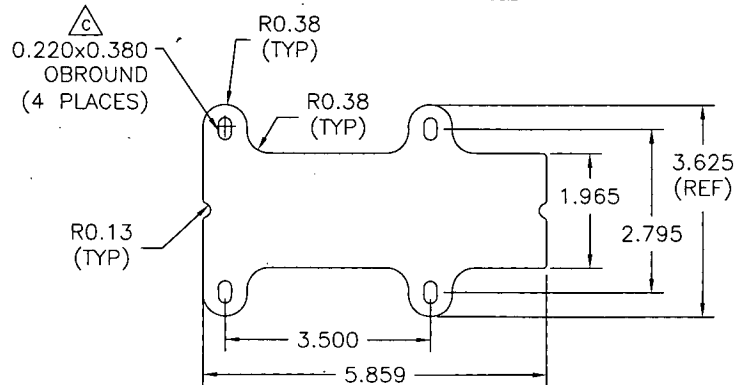
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

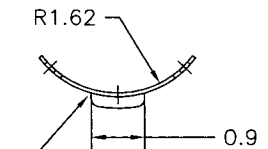
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

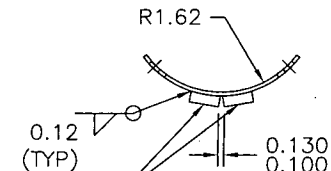


### SECTION A-A



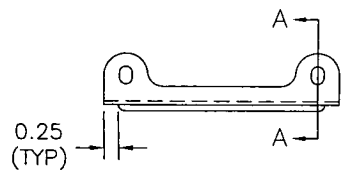
APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

### SECTION B-B

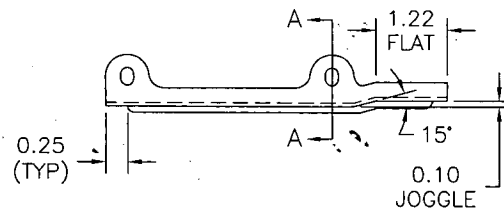


D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

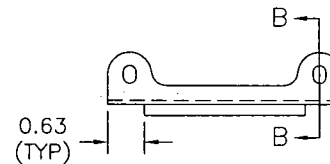
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



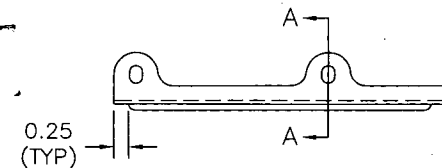
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
CHECKED	B	07.03.20	ADD AMS 5513 AND AMS 5524
DATE	A	06.11.06	NEW ISSUE
DRAWN BY	CB	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
APPROVED	#	#	DRAWING NO. D3537
DATE	07.04.13		TITLE WEARPAD
			REV. C SHEET 1 OF 1 SCALE 1:2

~~31725~~

DART AEROSPACE LTD		Work Order:	31725
Description: Wearpad		Part Number:	D3537-1
Inspection Dwg: D3537      Rev: A B		Page 1 of 1	

24 67.04.27

## FIRST ARTICLE INSPECTION CHECKLIST

**X**

## First Article

1

## Prototype

[illegible]

Measured by:	SAD
Date:	03/05/13

Audited by:	<i>SB</i>
Date:	<i>07.05.13</i>

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	